

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 13.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005503**Date Inspected:** 25-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, Oregon**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Hinge K Pipe Beams**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Oregon Iron Works, Inc. (OIW) jobsite in Clackamas, Oregon for the purpose of observing fabrication of the Hinge K Pipe Beams.

OIW Fabrication Shop-Bay 1:

QA Inspector Brannon randomly observed OIW personnel and 1 helper continuing in Bay 1 at the CNC mill for facing hinge k pipe beam post tension cap plate (A825M) MK#a109 in preparation for welding.

OIW Fabrication Shop-Bay 2 (sub-assembly):

QA Inspector Brannon randomly observed OIW qualified welder Mr. Tim O'Brien ID#O6 groove welding a hinge k pipe beam fuse section a124-15 (HPS 485 W). The complete joint penetration (CJP) weld is identified as weld joint #W3-01O. Mr. O'Brien was observed welding in the 1G (flat) position utilizing submerged arc welding (SAW) process with a 2.4mm diameter electrode, filler metal brand Lincoln Electric LA85 class F9A4-Eni5-G-H2.

QA Inspector Brannon observed the OIW QC CWI Inspector's Mr. Mike Gregson, Mr. Jose Salazar and Mr. Rob Walters verifying that the pre-heat and welding parameters were in accordance with the Welding Procedure Specification (WPS). Welding parameters measured by QA are as follows: 597 amps and 32.9 volts and a travel speed of 457mm per minute appear to be in conformance with welding procedure specification (WPS) 4020 revision number 0.

OIW Fabrication Shop-Bay 3 (sub-assembly):

QA Inspector Brannon randomly observed OIW personnel grinding inside hinge k pipe beam fuse section a124-6 (HPS 485 W) in preparation for welding internal ring stiffeners.

WELDING INSPECTION REPORT

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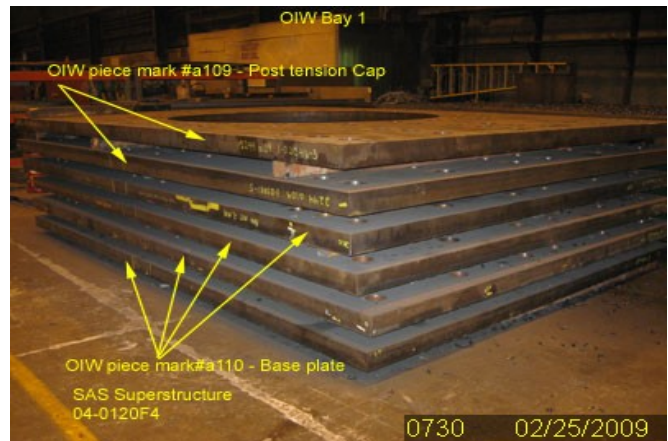
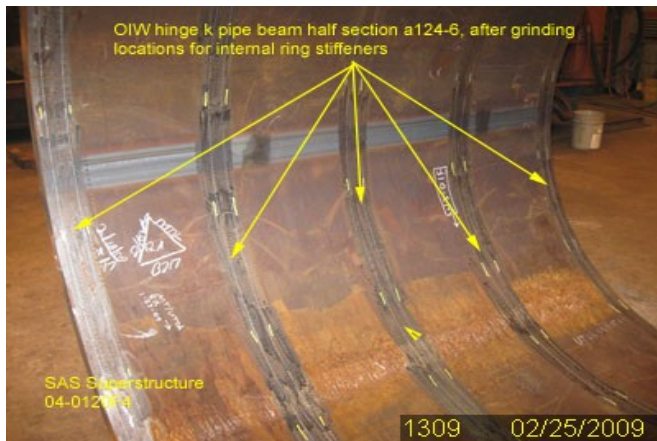
Quality Assurance Inspection (VT/MT):

QA Inspector Brannon performed visual inspection (VT) and magnetic particle testing (MT) on tubular fuse a124-7, complete joint penetration weld. See Caltrans Magnetic Particle Test Report TL-6028 dated February 25, 2009 for additional information.

Material, Equipment, and Labor Tracking:

QA Inspector Brannon performed a verification of personnel at OIW. QA Inspector Brannon observed 1 Supervisor, 3 Quality Control and 5 production personnel on this date.

The following digital photograph below illustrates observation of the activities being performed.



Summary of Conversations:

No relevant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Brannon, Sherri	Quality Assurance Inspector
Reviewed By:	Adame, Joe	QA Reviewer
